

Date: Tuesday, 05/05/2009 3:00:27 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 47743
 Estimate Number : 11645
 P.O. Number :
 This Issue : 05/05/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D29921
 First Issue : / / Type : SMALL / MED FAB Drawing Number : D2992 UNDER REVIEW
 Previous Run : 46789 Project Number : N/A
 Material :
 Due Date : 06/05/2009 Qty: 10 Um: Each
 Written By : LA
 Checked & Approved By : C 209/05/05
 Comment : Est B 02.03.06 Added dwg Rev.B NG
 Est Rev:C 08-04-22 now on water jet DD verified by:ec

Additional Product



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0802 sf(s)/Unit Total : 0.8022 sf(s)
 5052-H32 .040 Sheet
 Material: 5052-H32 0.040" sheet
 Batch: 109058 1B 9-5-5

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D2992
 Dwg Rev: A
 Prog Rev: A

1B 9-5-5



2-Deburr if necessary 1B 9-5-5

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1B 9-5-5

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8 09/05/06



5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

AL

09-05-06



W/O: 47743		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.05.01	1	KITS NOW AT CHG 004 W/ 4.00" WIDE DZ992-1 DOUBLER				09.05.06 GSI 042	NA 09.05.06
09.05.01	2	SHIP MODIFIED DZ992-1 DOUBLER 4.00" WIDE x 3.250' TALL x 0.040" THICK S052-H32 W/ R0.250 CORNERS B/N 109058				09.05.06 GSI 042	

Part No: D2992-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 47743

Part Number: D29921

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

16
DK 09-05-06

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C207103/06

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-06

POSITIVE RECALL

EFFECTIVE 090505 AUTH L1

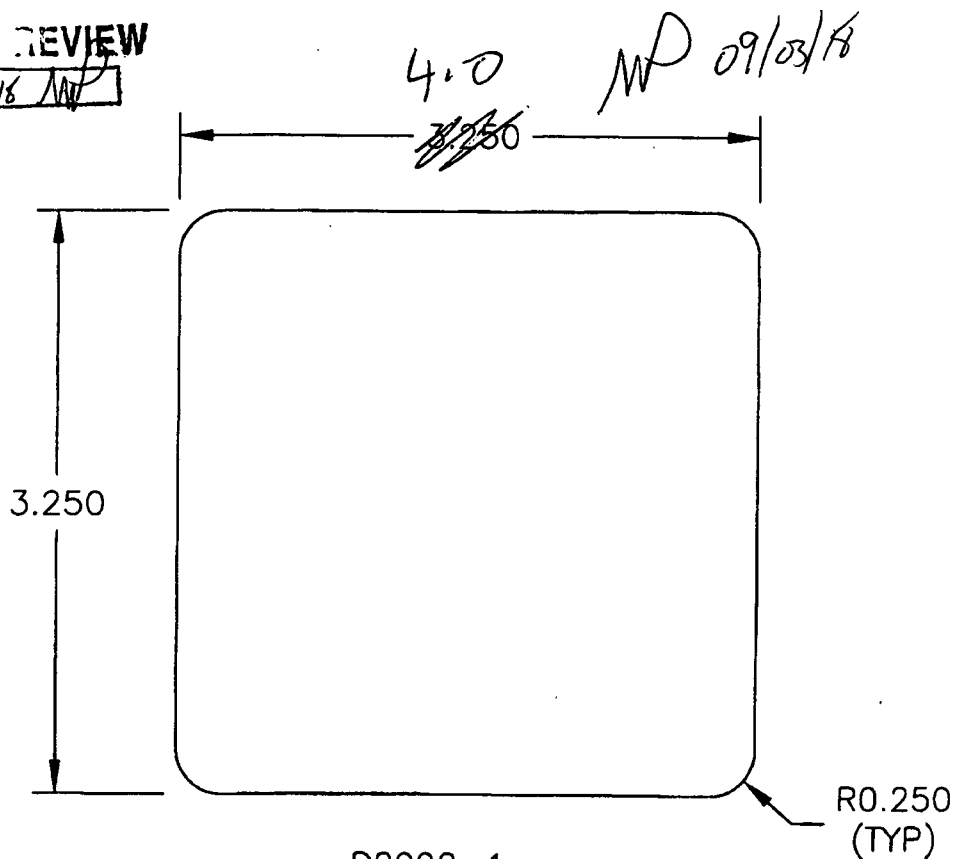
RELEASED CMP DATE 090506



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2992	REV. A SHEET 1 OF 1
DATE 02.01.21		TITLE DOUBLER	SCALE 1:1
A	02.01.21	NEW ISSUE	

RELEASED
02.01.25 *[Signature]*

UNDER REVIEW
07/03/16 *[Signature]*



D2992-1

C209/05/05

WID: 47743

NOTES:

MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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